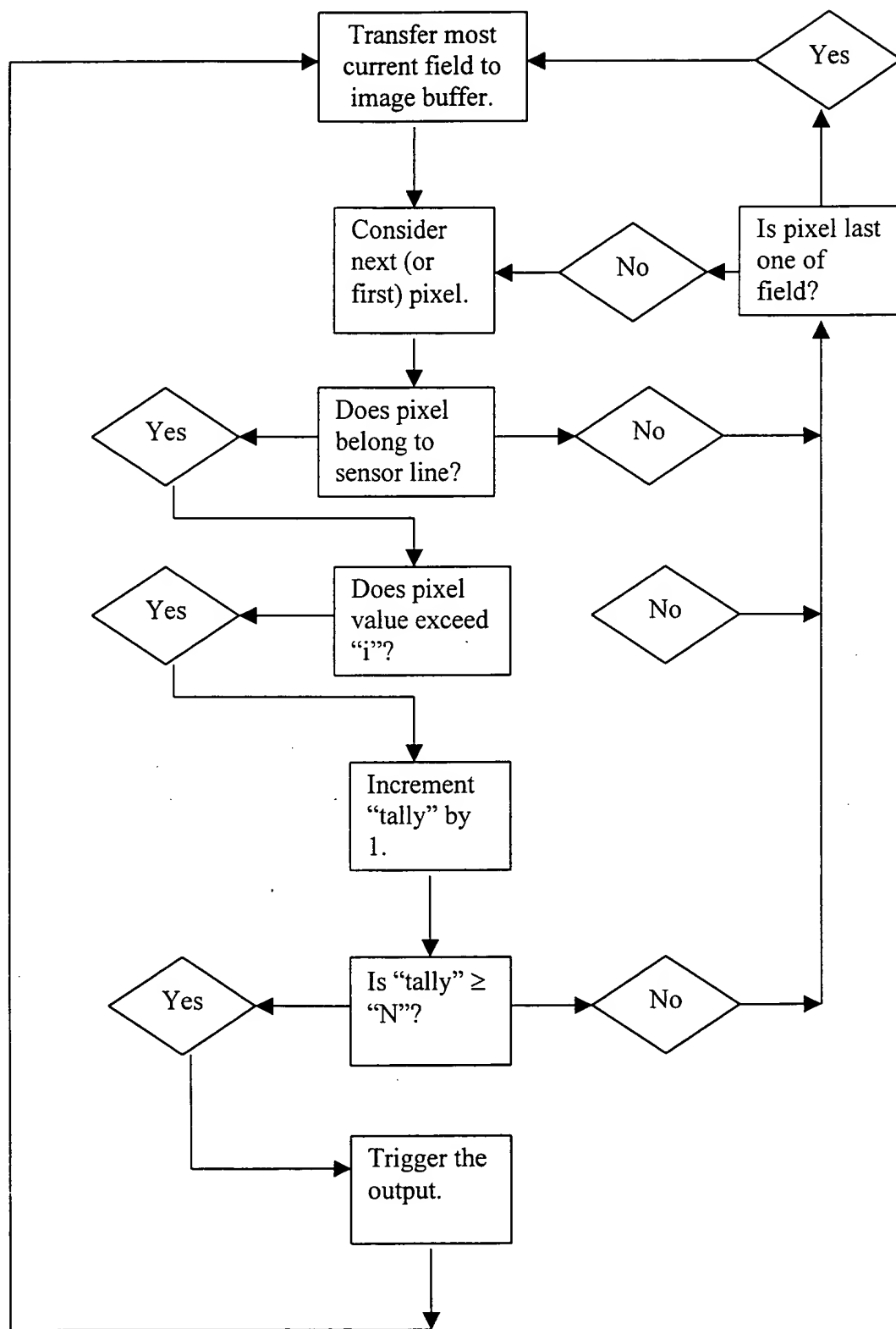


Figure 2

Figure 3



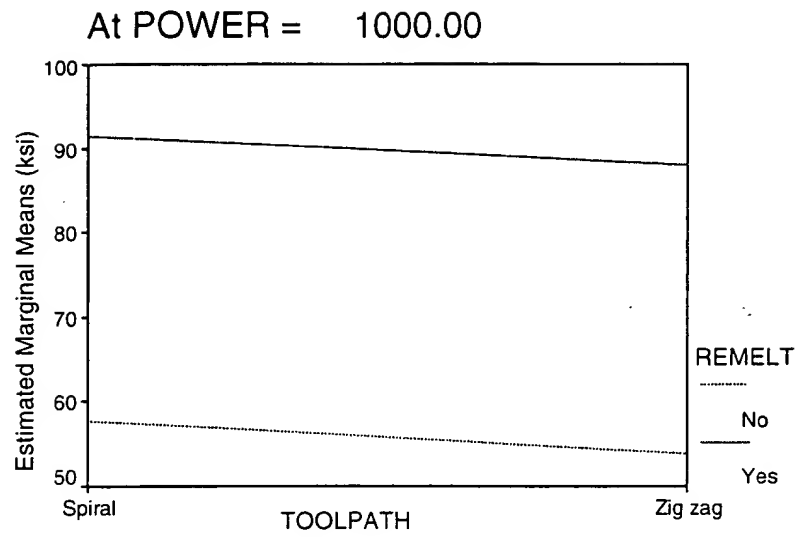


Figure 4A : Profile plot for Tool Path vs Remelt at Power = 1000 w

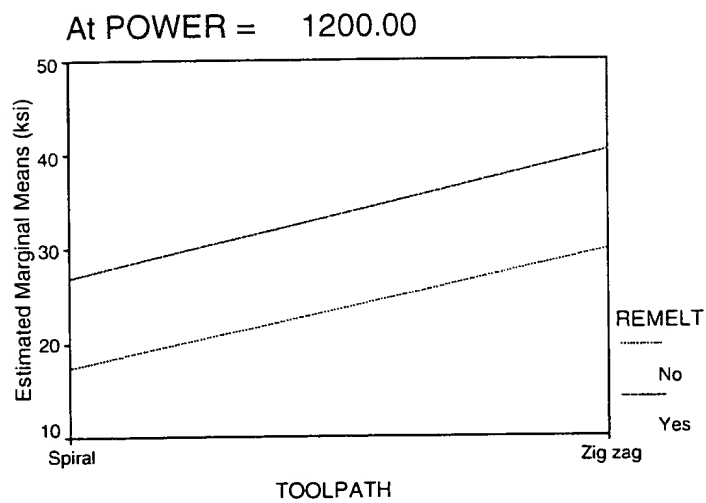


Figure 4B : Profile plot for Tool Path vs Remelt at Power = 1200 w

002000 00000000

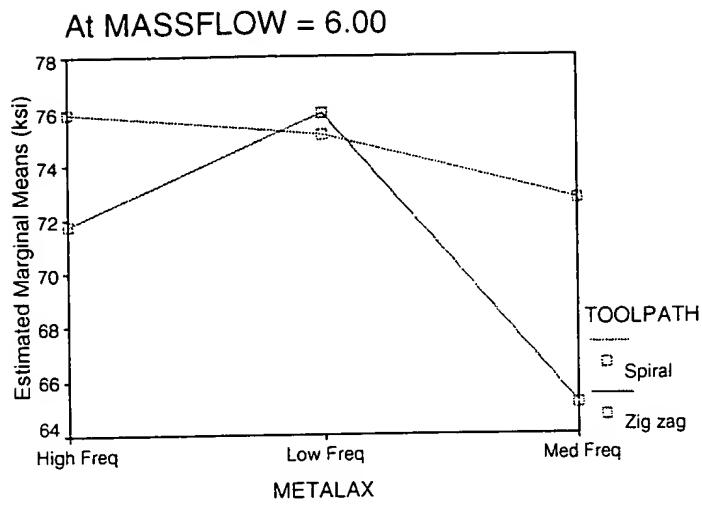


Figure 5A Profile plot for ToolPath vs Metalax at MassFlow= 6 gm/min

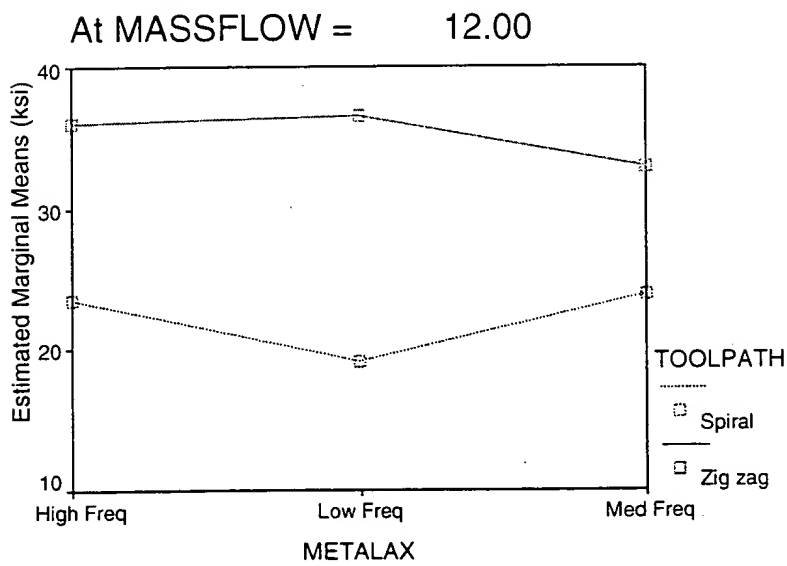


Figure 5B Profile plot for Tool Path vs. Metalax at Mass Flow = 12 gm/min

002200" 002200" 002200"

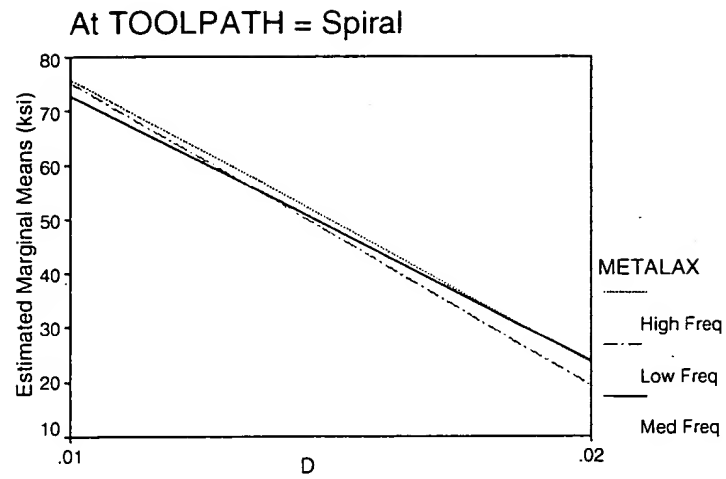


Figure 6A Profile plot for Layer thickness vs Metalax at Tool Path = Spiral

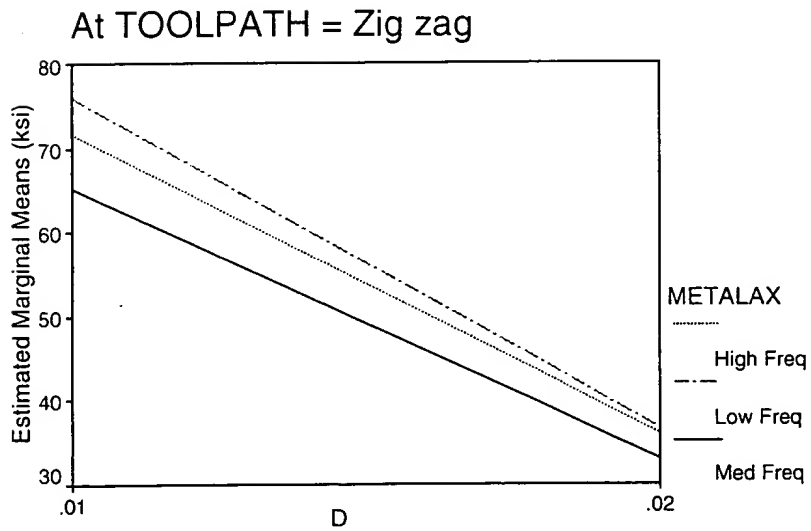


Figure 6B Profile plot for Layer thickness vs Metalax at Tool Path = Zigzag

002260" 32312960

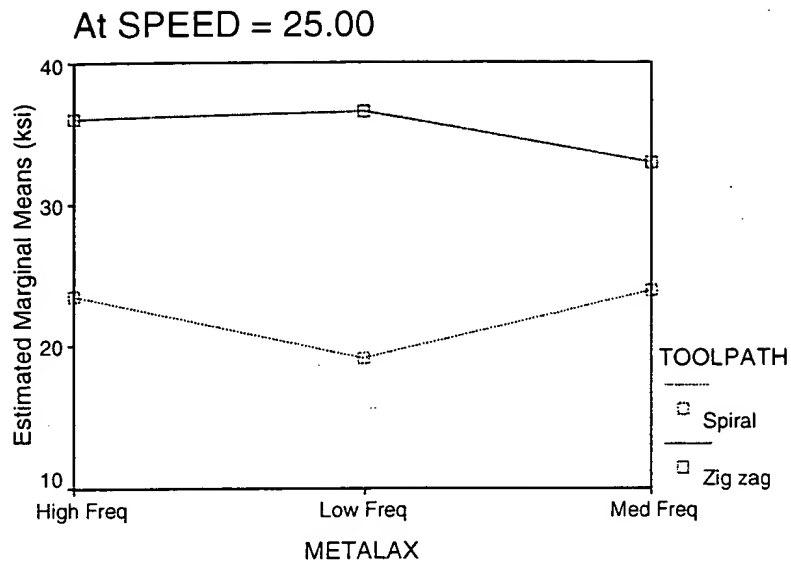


Figure 7A : Profile plot for ToolPath vs Metalax at Speed = 25 ipm

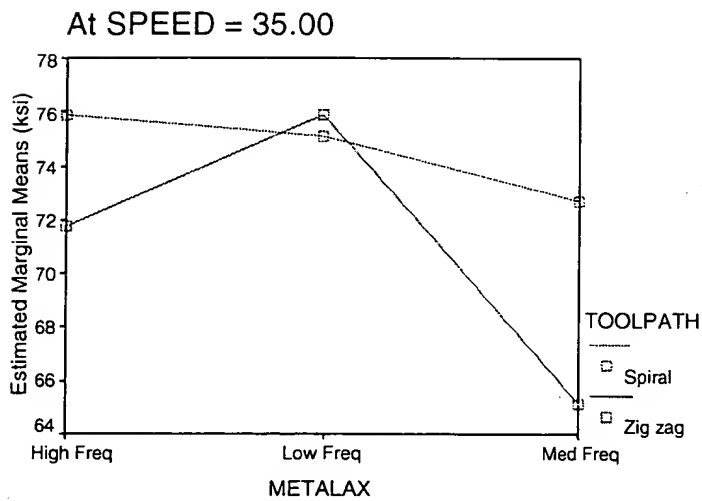


Figure 7B : Profile plot for Tool Path vs. Metalax at Speed = 35 ipm

33260" 33260" 33260"

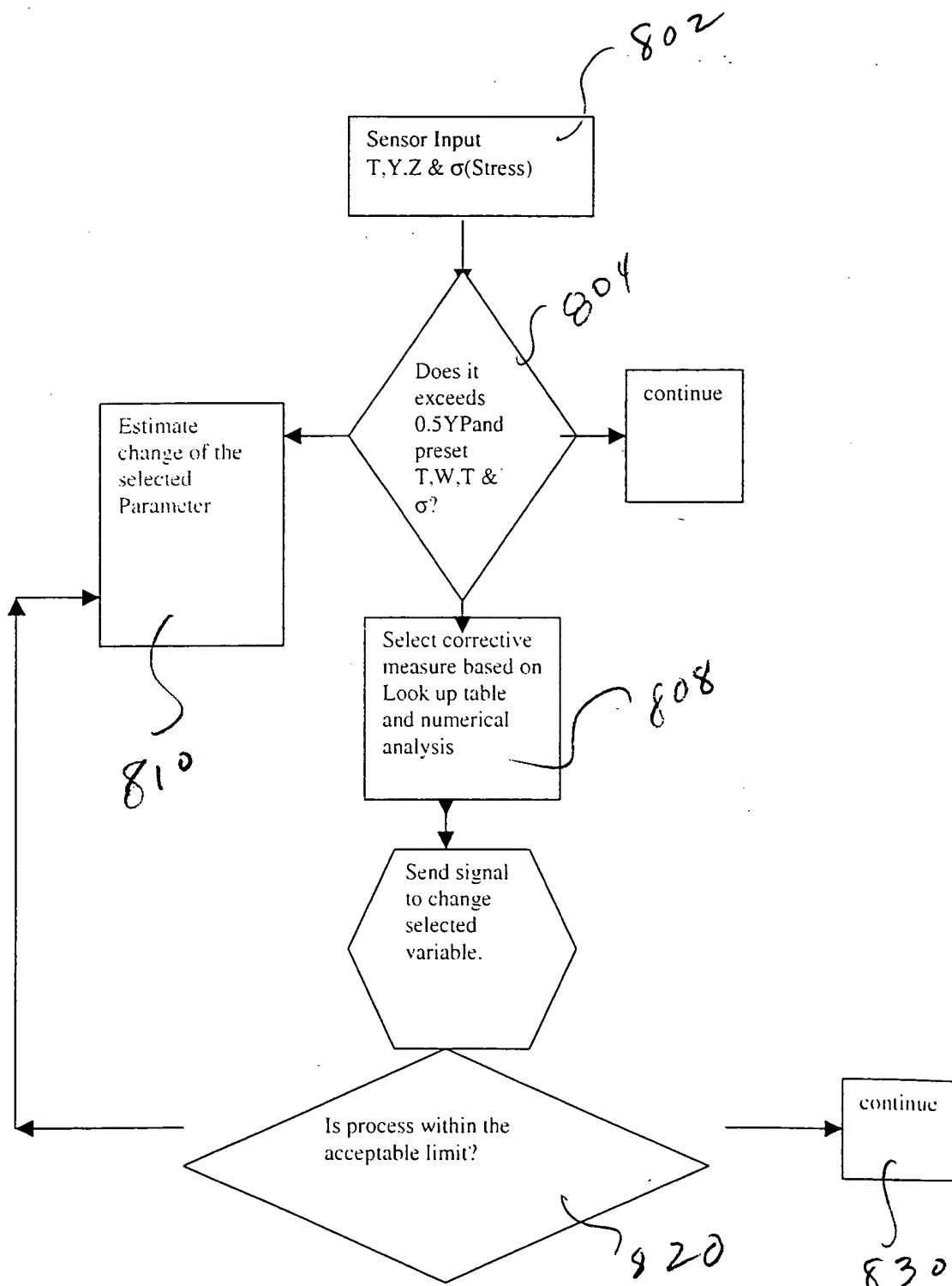


Fig - 8